

CLAIMS

1. Method for the manufacture of an angular transducer unit for an angular switching device (10), in which a transducer element (13) is inserted and fixed in an angled bush (16), characterized in that the transducer element (13) is brought into aligned engagement with a transducer receptacle (44) formed in a tool (40), for the precise positioning with respect to the transducer element (13), then the bush (16) is brought into aligned, at least partial positive engagement with a bush receptacle (46) appropriately constructed in the tool (40) for completing the transducer unit (12) the transducer element (13) is fixed in the bush (16), the transducer receptacle (44) is at least partly formed by a transducer centring device, which is inserted or engaged in a tool body (42) of tool (40) and/or the bush receptacle (46) is at least partly formed by a bush centring device (54), which is inserted or engaged in the tool body (42).
2. Method according to claim 1, characterized in that transducer element (13) is fixed relative to tool (40).
3. Method according to claim 2, characterized in that transducer element (13) is fixed by vacuum, adhesives, particularly an adhesive tape (56), and/or by magnets.

4. Method according to one of the claims 1 to 3,
characterized in that
the transducer centring device and/or bush centring device
(54) is fixed relative to the tool body (42).
5. Method according to claim 4,
characterized in that
the transducer centring device and/or bush centring device
(54) is fixed by adhesives, particularly an adhesive tape,
by vacuum and/or by magnets (52).
6. Method according to one of the claims 3 to 5,
characterized in that
the transducer element (13) is sucked onto the tool (40)
by means of at least one vacuum duct (60) in tool body
(42).
7. Method according to one of the claims 3 to 6,
characterized in that
a pressure compensation takes place on radially outer areas (15) of a sucked on transducer element (13) by means
of compensating ducts (62) in tool body (42).
8. Method according to one of the claims 1 to 7,
characterized in that
the transducer centring device is removed prior to fixing
transducer element (13) in bush (16).
9. Method according to one of the claims 1 to 8,
characterized in that
transducer element (13) is fixed in bush (16) by at least
partly filling the gaps (21) with foam and/or moulding ma-
terial.

10. Method according to one of the claims 1 to 9,
characterized in that
use is made of a tool (40) with steps (50), which as a
stop engages with a front end (19) and/or a setback shoul-
der (18) of bush (16).
11. Method according to one of the claims 1 to 10,
characterized in that
several transducer units (13) are manufactured in parallel
using one tool with a plurality of transducer receptacles
and bush receptacles.
12. Method according to one of the claims 1 to 11,
characterized in that
bush (16) is fixed relative to tool (40), particularly us-
ing a holder (48) provided on tool (40).
13. Method according to one of the claims 1 to 12,
characterized in that
several transducer elements (13) are inserted and fixed in
an angled bush (16).
14. Method according to one of the claims 1 to 13,
characterized in that
a shielding can is positively pressed into the bush (16).
15. Method according to claim 14,
characterized in that
the shielding can is fixed, particularly soldered to a
printed circuit board.

16. Method according to one of the claims 14 or 15,
characterized in that
the transducer unit (12) is soldered to a shielding can,
particularly by means of at least one clip provided
thereon.

17. Method according to one of the claims 1 to 16,
characterized in that
the bush (16) is brought into a positive and/or non-
positive engagement, particularly a locking engagement
with a printed circuit board.